



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3701-00-01
Job Sheet R190592



Part No: RBE350A94-3701-00-01 **Job Qty:** 11 pcs

Part Name: 7 Degree M/R Rigging Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No: per ECN19-531

Due Date: 2/20/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBE350A94-3701-00 Rev.E IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	11 pcs	2/20/19	2/20/19	0.00	0.37	Waterjet - Omax <i>Small-Fab</i>		<i>MLL</i>
140	QC 5	11 pcs	2/20/19	2/20/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
200	Packaging 3-1 - Stock - B4B	11 pcs	2/20/19	2/20/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		<i>MLL</i>
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		



Container No: S153616



Part: RBE350A94-3701-00-01

Job No: R190592

Serial No/Batch: S153616

Revision: E

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/19

DAS
30
9-85

19/02/19

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - FG	11 pcs	2/20/19	0.00 0.00	QC 21 - FG - 21	DAG 21
				QC 21 - FG - 70	9-30
				QC 21 - SA - 53	FEB 14 2019
Part Op 100 - Waterjet 2 OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary Descriptions: 140 - (QC5- Inspect part completeness to step on W/O), Engrave T/N, 7 deg. and arrows using Marktronic engraver as per DWG. 200 - 1-Identify and Stock 2-The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE350A94-3701-00	Main Rotor Rigging Tool	11 pcs (1 ea)	100-Waterjet - Omax - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	RBE350A94-3701-00	11	11	11	
Allocated Container Detail					
Qty	Container No	Location		Init	
1	S101439	conditional release		_____	
10	S039622	ga141c		_____	
Part Specifications					
Specifications could not be found.					

141C



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Tel (613) 632-5200
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RBE350A94-3701-00-01
Job Sheet R190330



Part No: RBE350A94-3701-00-01

Job Qty: 10 pcs

Part Name: 7° Main Rotor Rigging Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No: rework per ECN19-531

Due Date: 2/21/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBE350A94-3701-00 REV: B IPP REV: A 18.01.15 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B
18.08.23 New drawing DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 4	10 pcs	2/21/19	2/21/19	0.00	0.33	Small-Fab 2	
110	QC 2	10 pcs	2/21/19	2/21/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	

Engine - 01 on
part per ECN19-531

140 QC 5	10 pcs	2/21/19	0.00 0.00	QC 2 - 66	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Outsource - 4 - Anodize	10 pcs	2/21/19		GRO002-VC	10
180 Packaging 2-1 - Receive - B4B	10 pcs	2/21/19	0.00 0.00	Packaging 2 - 1 - B4B	N/R N/R
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	10 pcs	2/21/19	0.00 0.00	QC 6 - 42	N/R
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	

200	Packaging 3-1 - Stock - B4B	10 pcs	2/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - FG	10 pcs	2/21/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op **100** - Waterjet 2 OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC5- Inspect part completeness to step on W/O), Engrave T/N, 7 deg. and arrows using Marktronic engraver as per DWG.
170 - (Outsource process-Anodize per QSI017 4.1.10.1), -Issue P/O; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061 -Certificate of Conformity is required
180 - (Receive & Inspect for Damage & Mat'l Certs), Receive
190 - (QC6- All purchased or subcontracted products)
200 - (Identify as per dwg & Stock Location: _____), Identify and Stock
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3701-00	7° Main Rotor Rigging Tool	10 pcs (1 ea)	100-Waterjet - Omax - 1	10 5039622 1X 5101757

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	RBE350A94-3701-00	10	10	0

GA141C

Part Specifications
Specifications could not be found.

Plex 2/7/19 10:19 AM dart.lacelle.linda

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 19.01.30	Job No.: RB18-AIRBUS	ADR Yes/No: N	ADR Date: 19.01.30	ECN #: 19- 531
Product No.: DART TOOLING EUROCOPTER		Created By: VM	Approved By: [Signature]	
Product Name: M/R RIGGING TOOL		Checked By: [Signature]		

Reason for Change:
ADDED SPECIFIC P/N TO EACH TOOL & ADDED BOM TO DRAWING

Documents Released:

RBE350A94-3701-00 REV E

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 19-531

PAPERWORK UPDATE ☐ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		19.02.01
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		19.02.01
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MD		19.02.01
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	MD		
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

RELEASE RBE350A94-3701-00 REV E
RE-ENGRAVE RBE350A94-3701-00 REV D TO RBE350A94-3701-00-01 (NO REANODIZE REQD)
PUT RBE350A94-3701-00 REV D INTO SUPERCEED & CLOSE URF19-531

ECN Verified & Complete: _____ Date: _____

[Handwritten mark]

Linda Lacelle

From: Patrick Duval
Sent: Monday, February 4, 2019 9:05 AM
To: Linda Lacelle; John Chuprun
Cc: Steven Drouin
Subject: RE: ECN 19-531

Linda,

On your email for this URF you said that there was 11 in stock, those kit will need to be rework as per ECN19-531 by engraving -01 on the 7° part and no re-anodize is required.

Pat Duval
QA Coordinator

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www.dartaero.com
pduval@dartaero.com



From: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>
Sent: Friday, February 01, 2019 8:34 AM
To: Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Eric Lalande <elalande@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>; Jesse White <jwhite@dartaero.com>; John Chuprun <jchuprun@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Ross Black <rblack@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Support Eugene <support.or@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>
Subject: ECN 19-531

Hello All,

Please find a copy of ECN 19-531 attached.

Thank you,